



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3371-041
Job Sheet 199110



Part No: D3371-041

Job Qty: 2 pcs

Part Name: Tail Rotor Pedal Lock



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Due Date: 9/6/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Small Fab - 1	2 pcs	9/6/19	9/6/19	0.00	1.06	Small Fab - 1		DAS 58 9-89 FEB 18 2020
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
130	Small Fab - 2 - B4B	2 pcs	9/6/19	9/6/19	0.00	1.06	Small Fab - 1 - B4B		DAS 58 9-89 FEB 19 2020
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
140	Small Fab - 3 - B4B	2 pcs	9/6/19	9/6/19	0.00	1.06	Small Fab - 1 - B4B		DAS 58 9-89 FEB 19 2020
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
150	QC 5	2 pcs	9/6/19	9/6/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		

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					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS FEB 25 2020 40 9-89
					QC 5 - 61	
					QC 5 - 81	
160	Packaging 3-1 - Stock - B4B 2 pcs	9/6/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	DAS 74 9-89
					Packaging 3 - 4 - B4B	ST 448 FEB 26 2020
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA 2 pcs	9/6/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	DAS
					QC 21 - SA - 53	21 FEB 26 2020
Part Op 120 - ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT 1- Press dowel pins as per Dwg D3371, then assemble Descriptions: hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051. 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest. 3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5 4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut. Qty Part Number Description Batch A/R 262 Locktite						
130 - Assemble lanyard to cyclic sock as per Dwg D3384 Identify as D3384-045 MANUFACTURE D2690-24 LAND YARD AS PER DWG						
140 - 1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371. 2- Identify as D3371-041 & attach keys 3- Record the Key Number on page 4						

- 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - (QC21- Final Inspection - Work Order Release)

014526
 014528

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
238-028	3/16" Dowel Pin .5" long	4 Ea (2 ea)	120-Small Fab - 1	5226094
AN526C832R6	Screw	8 Ea (4 ea)	120-Small Fab - 1	5226094
D2728-7	Dart Logo Label	2 (1 ea)	120-Small Fab - 1	5208417
D3371-1	Pedal Lock Base	2 pcs (1 ea)	120-Small Fab - 1	5212303
D3371-3	Pedal Lock Cover	2 pcs (1 ea)	120-Small Fab - 1	5213020
D3373-7	Cam Lock	2 pcs (1 ea)	120-Small Fab - 1	51163943
D3385-3	Hinge	2 pcs (1 ea)	120-Small Fab - 1	5206332
CBL-1240	Cable	3.3332 ft (1.6666 ea)	130-Small Fab - 2 - B4B	5198626
CBL-460	Loop Sleeve	4 Ea (2 ea)	130-Small Fab - 2 - B4B	5251780
D3384-1	Cyclic Sock	2 pcs (1 ea)	130-Small Fab - 2 - B4B	5209763
HX-81	1/4"-20 SHCS 3/8" long	2 Ea (1 ea)	140-Small Fab - 3 - B4B	5207160
NAS1149F0463P	Washer (AN960-416)	4 Ea (2 ea)	140-Small Fab - 3 - B4B	545247854

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	238-028	4	32	0
	AN526C832R6	8	28	0
	D2728-7	2	0	0
	D3371-1	2	2	0
	D3371-3	2	1	0
	D3373-7	2	10	0
	D3385-3	2	9	0
130-Small Fab - 2 - B4B	CBL-1240	3	657	0
	CBL-460	4	727	0
	D3384-1	2	13	0
140-Small Fab - 3 - B4B	HX-81	2	23	0
	NAS1149F0463P	4	547	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S256668



Part: D3371-041

Job No: 199110

Serial No/Batch: S256668

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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